

taken to see that the amount of clearance is ample to take care of any condition which might be found. An inch of clearance all around is none too much on a large casting. The pot fixture // is centrally located on the table by the plug *J* and is fastened down by the T-bolts *O* in the table slots.

The set-screws at *B* and *C* serve as locating points for the casting. There are two screws at *B* and one at (\ the latter being located midway vertically between the other two and 90 degrees from them. This is somewhat contrary to the usual custom and in some cases might not be found desirable -- for example, when considerable dependence has to be placed on the locating screws to assist in driving the work. In this case, however, ample provision for driving is obtained. The work is forced over against points *B* and (' by the central set-screw *D* of the three shown. When the casting has been brought up snugly into place, the upper and lower screws *D* are also tightened. Protection against chips is provided for in connection with these set-screws, no portion of the thread *K* being exposed. The work rests on a fixed point (/ (shown in the upper view) which acts as a positive stop. Two additional points *F* are adjustable by means of a wrench, and their threads are protected from dirt by a cylindrical portion above. The openings *P* in the wall of the fixture allow access for the screws; the U-clamps *L* draw it clown upon the points by means of the nuts and washers *M* on the studs *A"*. The clamps *L* being of U-section are readily removable without requiring the nuts and washers to be taken off. The* plan view shows only one clamp in position in order to show this clearly.

Two Methods of Obtaining a Three-point Support
on a Hub Casting.— The work /I, shown in the upper portion of Fig. 3, is a hub casting of large size, and the method to be described was first suggested in connection with the handling of this work. The idea was abandoned, however, in favor of the method shown at the lower part, of the illustration, in the upper illustration, the jaws *C* are mounted on the raising blocks *R* and tongued to them at /?, while the raising blocks are tonguecl and fastened to the sub-jaws of the table at F. Three hardened